

## CLAIMS

What is claimed is:

1. An amino resin composition for cleaning molds, comprising 30 to 60 wt. % of thermosetting resin and 40 to 70 wt. % of at least one methylol-containing amino resin which has at least 75 wt. % of solid content.
2. The amino resin composition for cleaning molds according to claim 1, wherein said amino resin is selected from the group consisting of urea, amino compounds of malamine, formaldehyde and the derivatives thereof.
3. The amino resin composition for cleaning molds according to claim 1, further comprising xylon material, inorganic filling material, a releasing agent, and a hardening promoter.
4. The amino resin composition for cleaning molds according to claim 3, wherein said inorganic filling material is selected from the group consisting of metal oxides, metal hydroxides, metal carbonates, metal sulfates, metal sulfides, metal silicates, metal silicides, mineral powders, and glass fibers and the added amount is from 0.01 to 80 wt. %, based on the weight of the amino resin composition.
5. The amino resin composition for cleaning molds according to claim 3, wherein said inorganic filling material is mineral powder which has a mean particle size less than 150  $\mu$  m.
6. The amino resin composition for cleaning molds according to claim 3, wherein said releasing agent is selected from the group consisting of aliphatic releasing agent, aliphatic amido releasing agent, alcoholic releasing agent, paraffinic releasing agent and silicic releasing agent and the added amount is from 0.01 wt. % to 10 wt. %, based on the total weight of the amino resin composition.
7. The amino resin composition for cleaning molds according to claim 6, wherein the added amount of said releasing agent is preferably from 0.5 wt. % to 5.0 wt. %, based on the total weight of the amino resin composition.
8. The amino resin composition for cleaning molds according to claim 3, wherein said hardening promoter is selected from the group consisting of inorganic acidic hardening promoter, organic acidic hardening promoter, organic ammonium salt hardening promoter and inorganic metal salt

hardening promoter and the added amount is from 0.01 to 10 wt. %, based on the weight of the amino resin composition.

9. The amino resin composition for cleaning molds according to claim 3, wherein said xylon fiber material contains at least 80 wt. % of particles which can pass through sieve No. 80 and the added amount is within the range of from 10 wt. % to 80 wt. %, based on the total weight of the amino resin composition.

10. The amino resin composition for cleaning molds according to claims 1, wherein curing time of the amino resin composition for cleaning molds is in the range of 450 to 750 seconds, measured by using JSR type of curing meter.

11. The amino resin composition for cleaning molds according to claim 1 and 2, which is made into a tablet from.

12. The amino resin composition for cleaning molds according to claim 1 and 2, which is made into a sheet from.

13. The amino resin composition for cleaning molds according to claim 1, which is made into a powder from.

14. An amino resin composition for cleaning molds, said composition includes from 30 to 60 wt. % of thermosetting resin and 40 to 70 wt. % of a semi-cured additive of at least one methylo- containing amino resin which has at least 75 wt. % of solid content.

15. The amino resin composition for cleaning molds according to claim 14, wherein said amino resin is selected from the group consisting of urea, amino compounds of malamine, formaldehyde and the derivatives thereof.

16. The amino resin composition for cleaning molds according to claim 14, further comprising xylon material, inorganic filling material, a releasing agent, and a hardening promoter.

17. The amino resin composition for cleaning molds according to claim 16, wherein said inorganic filling material is selected from the group consisting of metal oxides, metal hydroxides, metal carbonates, metal sulfates, metal sulfides, metal silicates, metal silicides, mineral powders, and glass fibers and the added amount is from 0.01 to 80 wt. %, based on the weight of the amino resin composition.

18. The amino resin composition for cleaning molds according to claim 16, wherein said inorganic filling material is mineral powder which has a mean particle size less than  $150\ \mu\text{m}$ .

19. The amino resin composition for cleaning molds according to claim 16, wherein said releasing agent is selected from the group consisting of aliphatic releasing agent, aliphatic amido releasing agent, alcoholic releasing agent, paraffinic releasing agent and silicic releasing agent and the added amount is from 0.01 wt. % to 10 wt. %, based on the total weight of the amino resin composition.

20. The amino resin composition for cleaning molds according to claim 19, wherein the added amount of said releasing agent is preferably from 0.5 wt. % to 5.0 wt. %, based on the total weight of the amino resin composition.

21. The amino resin composition for cleaning molds according to claim 16, wherein said hardening promoter is selected from the group consisting of inorganic acidic hardening promoter, organic acidic hardening promoter, organic ammonium salt hardening promoter and inorganic metal salt hardening promoter and the added amount is from 0.01 to 10 wt. %, based on the weight of the amino resin composition.

22. The amino resin composition for cleaning molds according to claim 16, wherein said xylon fiber material contains at least 80 wt. % of particles which can pass through sieve No. 80 and the added amount is within the range of from 10 wt. % to 80 wt. %, based on the total weight of the amino resin composition.

23. The amino resin composition for cleaning molds according to claims 14, wherein curing time of the amino resin composition for cleaning molds is in the range of 450 to 750 seconds, measured by using JSR type of curing meter.

24. The amino resin composition for cleaning molds according to claim 14, which is made into a tablet form.

25. The amino resin composition for cleaning molds according to claim 14, which is made into a sheet form.

26. The amino resin composition for cleaning molds according to claim 1 and 2, which is made into a powder form.

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